Work Order ID 100115 April-18-13 9:26:24 AM

100115

Revision ID:	646.3512 Strut		Accept			1100) * ፡	Setup Star Stop	1.71	IS1* IS2*	
Start Date: Required Date: Reference:	4/18/13 Start Qty: 10.0 4/25/13 Req'd Qty: 10.0	1 1 7		Cust Item Customer:	ID:						
Approvals:	Process Plan: MLゴ QC:	• • • • • •			ate:		ł	Run Star Stop	"I V	R1*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr						Qij	Qiy	Number	Stamp	
646.3500	N/C (ECN)									pjo ,	
110			0.00								
110 Waterjet FLOW CNC Waterjet	1 001 07	6.3500 plate 2.00"X 2.00" as p	0.00 per Dwg				<u> 0</u>	o _		JM13-4-27	
GOON LAC.	Prog Rev	if necessary					,				
120	QC2- Inspect parts of	f machine FAI/FAIB	0.00							*	
120	Memo		0.00					_ 0		JM13-4-19	
Quality Control	viemo		0.00				10	٥		JM13-4-27	

										DQA.	Date.	1101/22		
NCR: Ye	es / No				WORK ORDER NON-O	CON	IFORN	/ANCE / UP	DATE	QA Closed:	L Date:	3/3/15		
Work Order	. 10	011	5	1	DISPOSITION	, i			AGAINST D	DEPARTMENT/PROCESS				
Part No	o. 64	6.3 6.3	5512		Rework Scrap Use-as-is Work Order Update Rework Skid-tube Machining Thermoforming Large Fab			Crosstube Small Fab Finishing Composite	Prod. Eng. Coor. Quality g Rec/Store/Packaging Other					
``Root		***			ption of work order update	1	nitial		tion	Sign &				
Cause	Date	Step	Qty	(or Non-conformance		ef Eng		ription	Date	Verification	QC Inspector		
quip/Tooling Operator Material Jetup Other Process Supplier Training Juapproved		100 HO	\o'\.	bue to when tube us to	tabing Cracking Forming end of Apical authorize o use Stainless Steel				plates cut h Email	M 17.04.25	13429	(DAS) 16 13/05/14		
	Q W	D 20	J		F	AUL.	T CATE	GORY						
Landin	g Gear Bending Centre No Cracks Crushed/O Cuffs Heat Trea	Crimped.		O/S	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled			Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled		
	Inspection	n Strip in	Tube		Cut Too Short	Misread			Power Loss/Surge Other					
. [Ripples in	Bend			Drill Holes		Offset					-		

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Work Order ID 100115 (4 4 5) *100115*

April-18-13 9:26:24 AM

Item ID: Revision ID:

646.3512

Strut

Accept

N900040100

Setup Start

Start Date: 4/18/13 Required Date: 4/25/13

Start Qty: 10.00 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference: Approvals:

Item Name:

Process Plan: Date: Tooling: QC: _____ Date: ____ SPC (Y/N):

0.00

Date:

Run

Sequence ID/ **Work Center ID**

Operation Description

QC8- Inspect parts - second check

Set Up/ **Run Hours**

Tool ID Tool # Plan

Date:_____

Code

Accept Qty

Reject Qty

Reject Insp.

Number Stamp

130

QC Quality Control

Memo

140

130

140 Small Fab

Small Fab

Memo

Memo

1- Fabricate tube as per dwg

0.00

0.00

10

150

150 QC

Quality Control

QC5- Inspect part completeness to step on W/O

		DQA:	Date:	1,000
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

	•								QA Closed:	Date:				
Mank Oad			· • in		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Work Orde	er:				Rework	1	Skid-tube Crosstube Water Jet Eng							
Part N	lo.				Scrap	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality			
raren	···			····	Use-as-is	Ther	moforming	Finishing	Rec/Stor	re/Packaging	Other			
NCR N	lo				Work Order Update]	Large Fab	Composite]	Supplier				
									Cian 8					
Root					ption of work order update	Initial	1	ction	Sign &	Verification	QC Inspector			
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	<u>Desi</u>	cription	Date	vernication	QC mspector			
Doc/Data														
Equip/Tooling														
Operator														
Material														
Setup														
Other					•	-								
Process	-					·								
Supplier														
Training														
Unapproved	L. L.	L			F	AULT CAT	EGORY		<u> </u>					
Landii	ng Gear				General									
Landi	Bending			Г	Bend	Grain			Ovalized		Pressure/Forced			
	Centre N	ot Concer	ntric to ()/s	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure			
	Cracks			<u> </u>	Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld			
	Crushed/	Crimped			Burrs	Instru	ctions Incomplete	·/Unclear	Part Lost/M	issing	Wrong Stock Pulled			
· — —					Contamination	Main	tenance		Part Moved					
	Heat Trea	at .			Countersink	Mislat	reled		Positioned \	Wrong	·			
Inspection Strip in Tube Cut Too Short						Misrea	ad .		Power Loss/	/Surge	Other			
Ripples in Bend Drill Holes						Offset								
Torque Waves in Extrusion Drawing						Out of Calibration								
Turning Sequence Finish						Out of Sequence								
	□wave/Tw	ist in Tuk	эе		Folio	Outsic	de Dimensions							

(P) 13-05-07

Work Order ID 100115 and the months

April-18-13 9:26:24 AM

120

Quality Control

Memo

OC

100115

Item ID: 646.3512 Accept *N900040100* Setup Start **Revision ID:** Item Name: Strut **Start Date:** 4/18/13 **Start Qty: 10.00** *10* Cust Item ID: Required Date: 4/25/13 Req'd Qty: 10.00 **Customer:** Reference: Run Process Plan: _____ Date: ____ Tooling: Approvals: Date: QC: _____ Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty **Qty** Number Stamp 160 Weld per dwg A/R Aluminum rod Batch: M/2025 0.00 *160* E 13-5-6 Large Fab 0.00 Large Fab Weld tube to plate as per dwg. 19868 Weld end were tube is punch. 170 QC9- Inspect visual per QS1004- Fusion Welds 0.00 *170* (9) 13.05-07 Memo 0.00 Quality Control 180 QC5- Inspect part completeness to step on W/O 0.00

0.00

NCR:	Yes	/	No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: ____

NCR: Y	es / No				WORK ORDER WORK		MARIOL / OF		QA Closed:	Date:	and the second s			
Work Orde	r:				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part N					Rework Scrap		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality			
NCR N					Use-as-is Work Order Update] Therr	moforming Large Fab	Finishing Composite						
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &					
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector			
Doc/Data														
Equip/Tooling		ļ								* .				
Operator														
Material		ļ. ·									·			
Setup														
Other								-						
Process	_						Ì				·			
Supplier														
Training	_													
Unapproved		<u> </u>				AULT CATE	CORV			<u> </u>				
					General	AULI CATE	GORT							
Langir [ig Gear Bending				Bend	Grain			Ovalized	Γ	Pressure/Forced			
}	Centre N	ot Conco	ntric to 1		BOM/Route	Hardw	aro	-	Over/Under	tolerance	Temperature/Cure			
	Cracks	or conce	nuic to t	^{5/3} -	Broken/Damaged	├ ─┤	tion Incomplete		Part Incorre	⊢	Weld			
ŀ		Crimped	•	-	⊣	—	tions incomplete	/Unclear	Part Lost/M	<u> </u>	Wrong Stock Pulled			
ŀ	Crushed/Crimped Burrs Cuffs Contamination					 	enance	,	Part Moved		~			
}	Heat Treat Countersink						eled		Positioned \					
Inspection Strip in Tube Cut Too Short						Misrea		<u> </u>	Power Loss,		Other			
Ripples in Bend Drill Holes					⊣	Offset				- <u>L</u>				
Torque Waves in Extrusion Drawing						H	Calibration							
					Finish	Out of Sequence								
Wave/Twist in Tube					Folio	Outside Dimensions								

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April-18-13 9:26:24 AM

100115

Item	ID:	646.3

3512

Accept

N900040100

Setup Start

Item Name: Strut

> 4/18/13 **Start Qty: 10.00**

10

Cust Item ID:

Required Date: 4/25/13

Req'd Qty: 10.00

Memo

Customer:

Reference: Approvals:

Start Date:

Revision ID:

Process Plan: Date: Tooling:

Date:

Run

QC: ______ Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description Run Hours Code Number Stamp Qty Qty 190 Outsoupe process-Anodize pen QSI017 4.1.1 1.1.1 0.00*190* Outsource4 Memo Outsource process - Anodize Issue P/O Anodize as per dwg 200 Receive & Inspect for Damage & Mat'l Certs *200* Packaging 0.00 Memo Packaging 210 QC5- Inspect part completeness to step on W/O 0.00

0.00

Quality Control

											DQA:	Date:			
NCR:	Yes	/ No				WORK ORDER NON-O	COI	VFORN	AANCE / UPDATE						
											QA Closed:	Date:	en e		
Work Orde	o r ·					DISPOSITION			AGAIN	AGAINST DEPARTMENT/PROCESS					
Work Orde	ei.					Rework	1		Skid-tube Crosstu	be		Water Jet	Engineering		
Part N	Vo.					Scrap	1		Machining Small Fab			d. Eng. Coor.	Quality		
, ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	•					Use-as-is	noforming Finish	ing	Rec/Stor	e/Packaging	Other				
NCR I	No.					Work Order Update		Large Fab Compos	ite						
			r	<u> </u>	Doscri	ption of work order update		Initial	Action	/// IM	Sign &				
Root		Date	Step	Qty		or Non-conformance	ļ	nief Eng	Description		Date	Verification	QC Inspector		
Cause Doc/Data		Date	Step	Qty		or won-comormance	+=	iicr Erig	Cescription	· · · · · · · · · · · · · · · · · · ·					
Equip/Tooling	\vdash								,						
Operator	Н														
Material															
Setup															
Other															
Process					i										
Supplier															
Training	Г	٠.													
Unapproved															
						F	AUI	LT CATE	GORY			·			
Landi		1				General	_	7			٦	F	-		
		Bending	-		<u></u>	Bend	_	Grain		\vdash	Ovalized	<u> </u>	Pressure/Forced		
	<u> </u>	Centre N	ot Conce	ntric to	o/s	BOM/Route	-	Hardwa		-	Over/Under	⊢	Temperature/Cure		
	<u></u>	Cracks			-	Broken/Damaged	<u> </u>	-	on Incomplete	-	Part Incorre	<u>-</u>	Weld		
	-	Crushed/	Crimped	-	ļ	Burrs	-		ions Incomplete/Unclear	-	Part Lost/Mi	issing	Wrong Stock Pulled		
	<u> </u>	Cuffs			<u> </u>	Contamination	-	Mainte		<u> </u>	Part Moved	44			
	<u> </u>	Heat Trea				Countersink		Mislabe		-	Positioned V	_	7045		
	-	Inspectio	•	Tube		Cut Too Short	-	Misread	1	L	Power Loss/	Surge	Other		
l		Ripples in	n Bend		1	Drill Holes		Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 100115 (17) 27 44 April-18-13 9:26:24 AM

100115

Revision ID: Item Name: Start Date: Required Date: Reference:	Strut 4/18/13 4/25/13	Start Qty: 10.00 Req'd Qty: 10.00	*10 [*] *10 [*]		*N90004010 Cust Item ID: Customer:			^ *	Setup S	Start *NS1* Stop *NS2*
Approvals:	Process P QC:	lan:		Tooling: SPC (Y/N):		ate:		F		*NR1* *NR2*
Sequence ID/ Work Center II 220 *>>>)	Operation Description Memo Prime as per Batch:	dwg (see note 3) ひょう	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	
230 *230* QC Quality Control		- QC14- Inspect Spray Pain Memo	t .	0.00	•			9		(0 5 13.05.10
240 *740* Packaging Packaging		Receive & Inspect for Dan . . Memo ***IDENTIF!		∕0.00 0.00 P-120 BY STAMPING TH	E P# AND			Q X		

80018

											DQA:	Date:	* /
NCR:	Yes	/ No				WORK ORDER NON-C	ON	NFORN	AANCE / UP	DATE	QA Closed:	Date:	
						DISPOSITION		·		AGAINST DE	PARTMENT	/PROCESS	
Work Ord Part I NCR I	۰ No					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Ī	nitial	Ac	tion	Sign &		
Cause	1	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						F	AUI	.T CATE	GORY				
Land	na C	Geor			 	General	701	CAIL	-				
Carto	Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete/ enance eled d	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
İ		Torque V	Vaves in I	Extrusio	n [Drawing		Jour of (Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

Work Order ID 100115

April-18-13 9:26:24 AM

100115

Item ID: 646.3512
Revision ID:
Item Name: Strut

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 4/

Required Date: 4/25/13

4/18/13

Start Qty: 10.00 **Req'd Qty:** 10.00

10

Cust Item ID:

Customer:

Reference:

 Approvals:
 Process Plan:
 Date:
 Tooling:
 Date:

 QC:
 Date:
 SPC (Y/N):
 Date:

tart *NR1*

NR2

Sequence ID/ Work Center ID

Operation Description

Set Up/ Run Hours Tool ID

Tool # Plan Code Accept Qty

Run

Reject R Qty N

Stop

Reject Insp. Number Stamp

250

250

ソ5() QC

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

13/5/13

MF 5-13

Quality Control

NCR: Y	es / No				WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:									
Work Orde	r:				DISPOSITION	,	. []	AGAINST DE	PARTMENT,	PROCESS Water Jet	Engineering			
Part N NCR N					Scrap Machining Sr Use-as-is Thermoforming F Work Order Update Large Fab Co				Fab Prod. Eng. Coor. Quality hing Rec/Store/Packaging Other Supplier					
Root				Descri	ption of work order update	Initial	Act	tion	Sign &					
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Desc	ription	Date	Verification	QC Inspector			
Ooc/Data Equip/Tooling Operator Material Setup Other			-											
Process Supplier Fraining Unapproved									4					
		<u> </u>	<u></u>		F	AULT CAT	EGORY							
Landir	ng Gear				General				-		,			
	Bending Centre No Cracks Crushed/ Cuffs			o/s	Bend BOM/Route Broken/Damaged Burrs Contamination	Instru		Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled				
Heat Treat Inspection Strip in Tube Ripples in Bend • Torque Waves in Extrusion					Countersink Cut Too Short Drill Holes Drawing	Misre			Positioned V Power Loss/		Other			
					Finish	Out of Sequence								
Wave/Twist in Tube					Folio	Outside Dimensions								

DQA:

Date:

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Parent Item Name:

100115 *646 3512* Page 1

Start Date: 4/18/13

Required Date: 4/25/13

Start Qty: 10.00

Required Qty: 10.00

Parent Item:

IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last t	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.100 **MAAAATA 6061-T6.100 Sheet	S-100*	Purchased	No				sf	148.1000	**	0. 29473 7			JmB-4-19
M3045.	100" th	ick		Location MAT021	102201	<u>Loc (</u>	<u>Oty</u> 48.1	Loc Code					

B# 113062 M6061T6T0.500W.065 Purchased No

102201 118072 11.2 118523 60 124193 Q4193 75.9 131.8500 10.52632

Loe Oty

**

Loc Code

FF 13-04-29

M304 TO. SOOW 049

646.3512

Strut

131.85 MAT014 131.85 117590 -5 123449 -4" 120633 4

Location

See attach E-mail

⁄es	/ No				WORK ORDER NON-	CON	VFORN	ANCE / UPI	DATE			
7.									-53.51	QA Closed:	Date:	
er:		é-			DISPOSITION	,	N ₁	Skid-tuhe	-	DEPARTMENT/		Engineering
No.	1.				Scrap Use-as-is		Therm	Machining of orming of orming of the second	Small Fab Finishing		l. Eng. Coor. e/Packaging	Quality Other
۱o					Work Order Update	ا		Large Fab	Composite		Supplier	
	Date	Step	Qty_			1				Sign & Date	Verification	QC inspector
		<u> </u>			F	AUL	T CATE	GORY				
	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped at n Strip in n Bend	ı Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Inspecti Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/ nance led	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W	tolerance et ssing '	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	ong C	ng Gear Bending Centre No Cracks Crushed/ Cuffs Heat Trea Ripples in	Date Step Date Step Qty_ Date Step Qty_ Date Step Cty_ Bending Centre Not Concentric to Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend	Date Step Qty	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Step Qty_ Description of work order update or Non-conformance Date Step Qty_ Bend Bend Bending General Bending Centre Not Concentric to O/S Cracks Broken/Damaged Burrs Crushed/Crimped Burrs Cuffs Contamination Countersink Heat Treat Countersink Inspection Strip in Tube Ripples in Bend Drill Holes	Part Disposition	Primary Contention of the Content of Content	Principles of the principles o	Part Category Bending Centre Not Concentric to O/S Cracks	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Step Qty Or Non-conformance Bending Centre Not Concentric to O/S BoM/Route Bending Centre Not Concentric to O/S Crasks Grasks Crushed/Crimped Centre Not Concentric to O/S Crasks Crushed/Crimped Burrs Districtions incomplete Instructions Incomplete Instructio	DISPOSITION Rework Scrap Use-as-is Work Order Update Work Order Update Date Date Step Qty Description of work order update or Non-conformance Chief Eng Description Date Verification Bending Centre Not Concentric to O/S Cracks Description of Work Date Date Composite Composite Composite Composite Composite Composite Chief Eng Description Date Verification FAULT CATEGORY General Bending Centre Not Concentric to O/S Cracks C	

Out of Sequence

Outside Dimensions

DQA:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

	ENGINEERING CHANGE		02440	SHEET	<u>OF 1</u>
APICAL		REVINC PREPARED S	S. HUFF IDATE	06/08/09 EFFE	ECT ON DW IC. 🖾 UNIN
INDUSTRIES, INC.	DWG TITLE:	/ / STRU		A / 1555	
TRANSACTION CORES (TO)	APPROVED BY ENGR	MFG	2 00	EFF: CURRENT OR	DER AND STO
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED GEOMETE	KY IU AUCHMUUAHE M	EW EXISTING AIRCRA	# IN PRUVISIUNS	
	the second secon				7.
SHEET 2 IS:	- 54°·				
	130				
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·				,	
•			64 64	46.3512 SHOWN 6.3513 OPPOSITE	
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	72 R 650			Sale	
		/	7	A STATE OF THE STATE OF	
)(8 25)	36.	58,	/ 	Value of the strike	
j.	7:60			Sauren Comment	
3.7	California			NO _100115 MC	<u> </u>
		2.00	20	13-04	-18
	.100	200	2.37		
	4 90	L.VV -			
·	(5.51)				
DOCUMENTS EFFECTED:			CHANGE CATEGORY	DER REVIEW REQUIR	₹ED
	☐ MDL ☐ INSTALL INSTRUC	☐ ICA ☐ FMS ☐ B☐M	1 SONIM B ROLAM O	☐ YES ☒ N☐	

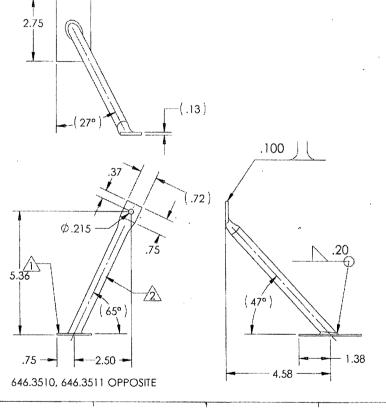
NOTES:

2 1. MATERIAL: 6061-T6 ALUMINUM IAW AMS-QQ-A-250/11; .062" THK.

MATERIAL: 6061-T6 ALUMINUM IAW AMS-WW-T-700/6 .500" OD; .062" WALL THK

FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2 COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377 J TYPE I CLASS N

- 4. DEBURR AND BREAK ALL SHARP EDGES
- WELDS IAW MIL-STD-2219. TIG WELD WITH FILLER ROD



- 1.50

646.3510 SHOWN 646.3511 OPPOSITE

UNINCORPORATED ECN(s)

02197, 02440

	1	646.3513	STRUT	△12√27	Z3\			
		646.3512	STRUT		⅓			
	7	646.3511	STRUT		Z3\			
		646.3510	STRUT		<u>A</u>			
	FIND #	FART#	DESCRIPTION	MATI	SPEC.			
OTY			PARTS LIST	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,				
NEXT ASSY 646,4000	[S] (MG-	TIAL DATE DA YE) DA 2345 HINEY CHECKEY DEPSSON P. BRAYO HISC AIRPOVAL CO	2608 TEMPLE HEK	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5900				
	24.23 25.23 COM	racins S		STRUT				
	Doke iou	ISS OTHERWISE SPECIFE PUSIONS ARE IN PICHES EXINCES AUF- NOE DECRMAIS ± 01 NOE DECRMAIS ± 025	B 07MZ6	646.3500	PIV. N/C			
1	ANG	KES T S'	SCALE NONE	\$ 59	EET 1 OF 2			

DART AEROSPACE LTD	Work Order:	100115
Description: Strut	Part Number:	646.3512
Inspection Dwg: (4/6.3500 Rev: N/c		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	2.00"	71-0.010	2.007			V	Jkmoi
	2.00"	41-0.010	2.002"	-		U	
	O. 463	41-0.010"	0095			V	
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Preliminary Approval: Measured by: Audited by: Date: Date: 13-4-19 Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

\$ 10.04.15

David Duval

From:

Pablo Bravo

Sent:

Wednesday, April 24, 2013 2:23 PM

To:

Jean-Luc Menard

Cc:

David Duval; Linda Lacelle

Subject:

RE: 646.3510/3511/3512/3513 STRUT ASSY

JL,

This should be okay.

Pablo

From: Jean-Luc Menard

Sent: Wednesday, April 24, 2013 9:15 AM

To: Pablo Bravo

Cc: David Duval; Linda Lacelle

Subject: Fwd: 646.3510/3511/3512/3513 STRUT ASSY

Any news on this?

Sent from my iPhone

Begin forwarded message:

From: Jean-Luc Menard < imenard@dartaero.com >

Date: 22 April, 2013 10:27:05 AM EDT **To:** Pablo Bravo pbravo@dartaero.com

Cc: David Duval < dduval@dartaero.com >, Linda Lacelle < llacelle@dartaero.com >

Subject: 646.3510/3511/3512/3513 STRUT ASSY

Hi Pablo,

We have started manufacturing the struts and have run into some problems with cracking when punching/bending the end of the struts.

Would going to 304 ss tubing with .049" wall be an acceptable deviation? This would include changing the bottom plate that gets welded on also to SS. Let me know asap so I can attach to the w/o and if acceptable I will issue a ECR.

THX

JL

DART AEROSPACE	LTD	Work Order:	100115	
Description: 646.35	312	Part Number:	646.3512	
Inspection Dwg:	Rev: UC		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.37"	+1030."	2.37 '	V.		tope	***************************************
501"	t/027"	< ~ ``	~		tope	
8,35" 36" 54' 25" 200"	** OSO"	5.25° 35°	\(tape	
36"	*/- °	35°	/		protractor	
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Measured by:	09	Audited by:	Preliminary Approval:	
Date:	13.05.07	Date:	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

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